

WORK ORDER 2009-18

Date opened: 13 August 2009

Project: Quick Release Cargo Basket Assembly
Type: Bell 206L Series, 407Batch Quantity: 5 Complete Basket Assemblies (69810-01)
All Modified with Open Front End (70405)

Approval: SH00-48

Drawing List: DCL698-1, DCL704

Fabrication and Assembly Drawing(s)	Description
69810, Rev. 2	Basket Ass'y
69811, Rev. 2	Basket Body Ass'y
69812, Rev. 1	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 1	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y
70404, Rev. 0	Open Front End Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y ✓
Document Control List revision level matches (or exceeds) STC:	Y ✓
Drawings revision levels match Document Control List:	Y ✓
Purchase order or Work order source is recorded for each part/ass'y:	Y ✓
Tests and inspections specifically called out on drawings are complete:	Y ✓
Release tags associated with all fabricated parts are attached:	Y ✓
All mounting hardware and supplies are included:	Y ✓

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Inspector Signature: Jeff Clark Date: 18 Dec 2009

Drawing: 69810 Revision 2
 Assembly: 69810-01 Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
5 Total	69810-01	Cargo Basket Assembly			
1	69811-01	Basket Body Assembly	Below		
1	69812-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	8093	
1	MS20001P4	Piano Hinge		8104	
1	69827-01	Placard	0.063" Sheet, 6061-T6 Aluminum	8062	
3	49205-14	Bumper	Argus Industries Bumper	8071	
26	CR3213-4-02	Cherry Rivet		8073	
4	40088-14	Fitting	Ancra	8077	
4	AN960-616	Washer		8067	
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		7077	
4	AN960-10	Washer		8048	
2	AN970-3	Washer		8067	
2	MS21044N3	Nut		7077	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		JC
Final Inspection	Drawing 69810			JC.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 69811 Revision 2
 Assembly: 69811-01 Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	69811-01	Basket Body Assembly			
2	69821-01	End Hoop (Rev. 1)	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
4	69823-02	Lug	1018 Mild Steel, 5/8" Rod	8022	
3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
4	69825-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
2	69826-01	Strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	8022	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69811			
Final Inspection	Drawing 69811			

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Drawing: 69812 Revision 1
Assembly: 69812-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	69812-01	Basket Lid Assembly			
2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
3	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	8022	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69812			
Final Inspection	Drawing 69812			

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	8058	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	8088 7047	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		8048	
2	MS21044N3	Nut		7077	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			JC

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Drawing: 36261 Revision 1
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	8076	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	8076	
2	MS20615-4M3	Monel Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			<i>JC</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 70404 Revision 1
Assembly: 70404-01 Open Front End Modification

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	70404-01	Open Front End Modification			
1	70404-03	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
1	70404-04	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
1	3/4-16F	Mesh	Expanded Carbon Steel	8094	

Note: Remainder of assembly listed on drawing 69811

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70404			jc

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 70405 Revision 0
Assembly: 70405-01 Lid Step Modification

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	70405-01	Lid Step Modification			
1	70405-03	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
1	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	6005	
14	CR3213-4-2	Cherry Rivet		7010	

Note: Remainder of assembly listed on drawing 69812

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			JC

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2009-18
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	69810-01	1	69801-31	New
12. Remarks Modified with Lid Step and Open Front End IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name JEFF CLARKE		13e. Date (dd/mmm/yyyy) 18 Dec 2009		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					


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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	69810-01	1	69801-34	New
12. Remarks Modified with Open Front End IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
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13d. Name JEFF CLARKE		13e. Date (dd/mmm/yyyy) 18 Dec 2009		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	69810-01	1	69801-36	New
12. Remarks Modified with Lid Step and Open Front End IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name JEFF CLARKE		13e. Date (dd/mmm/yyyy) 18 Dec 2009		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	69810-01	1	69801-37	New
12. Remarks Modified with Open Front End IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name JEFF CLARKE		13e. Date (dd/mmm/yyyy) 18 Dec 2009		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

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4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2009-18		
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work		
	Cargo Basket	69810-01	1	69801-35	New		
12. Remarks Modified with lid step and front end cutout IAW DCL704							
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.				
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number	
13d. Name JEFF CLARKE		13e. Date (dd/mmm/yyyy) 30 DEC 2009		14d. Name		14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>							

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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	69810-01	1	69801-31	New	
12. Remarks Modified with lid step and front end cutout IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 06 July 2010		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

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1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2009-18
6. Item	7. Description Cargo Basket	8. Part Number 69810-01	9. Qty. 1	10. Serial/Batch No. 69801-34	11. Status/Work New
12. Remarks Modified with front end cutout IAW DCL704.					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 11 June 2010		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

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4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2009-18	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	69810-01	1	69801-36	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number
		AMF 73-04				
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
Jeff Clarke		07 May 2010				
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

EXPEdition

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2009-18	
6. Item	7. Description Cargo Basket	8. Part Number 69810-01	9. Qty. 1	10. Serial/Batch No. 69801-37	11. Status/Work New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 22 Mar 2010		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

TRANS NORTH Heli